



Dart Hawkesbury
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D3172-041
Job Sheet 168686



Part No: D3172-041

Job Qty: 1 ea

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/21/17

Job Tracking No:

Due Date: 12/15/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV D IPP Rev:B 04.01.05 Added Step 5 inspection KJ/RF IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D 11.04.04 added pressure wash DD VERF:EC IPP REV:E 16.11.03 AS PER DWG REV.D DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		12/13/17	0.00	0.00	Start Up Large Fab-2		SG 2017-12-13
100	Large Fab	1 pcs		12/14/17	0.00	25.00	Large Fab 8		LL 17-12-13
110	QC	1 pcs		12/14/17	0.00	0.00	QC9		PD 17-12-20
120	QC	1 pcs		12/14/17	0.00	0.00	QC5		PD 17-12-20
130	HandFinish	1 pcs		12/14/17	0.00	0.38	HandFinish2		BR 17-12-21
140	Powdercoat	1 pcs		12/15/17	0.00	1.04	Powdercoat1		BR 17-12-21
145	Packaging	1 pcs		12/15/17	0.00	0.00	Packaging3		
150	QC21-SA	1 Ea		12/15/17	0.00	0.00	QC21		DEC 27 2017

Part Op 100 - 1-Cut Qty 4 D3166-1 as per Dwg D3172 2-Cut 3/4" x 3/4" square tubing as per Dwg D3172 3-Drill holes in D3172-3 Descriptions: as per Dwg D3172 4-Deburr & Remove all markings from material 5-Weld all ribs as per Dwg D3172 using Welding Table 6- Weld top D3174-1 ONLY bottom ones will be welded after mesh is install as per dwg 7- Weld D5365-1 as per dwg in (2) locations. From edge of back basket corn (without hinge) to bottom of D5365-1 lug. And (2) located at the front. 8- Weld mesh as per dwg 9- Use DT 8996 jig to locate the bottom D3174-1 as per dwg

140 - 1ST COAT: START TIME: 1:15 OVEN TEMPERATURE: 375° FINISH TIME: 1:30

***** 2nd coat if necessary ***** 2ND COAT: START TIME: _____ OVEN

TEMPERATURE: _____ FINISH TIME: _____

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	F156858 D2232-3 P154490	2	16	0	0
	D2227-3 F154190	2	15	0	0
	D2581 S005842	2	87	0	0
	D3166-1 S017277	4	43	0	0
	D3174-1 S016857	8	3	0	0
	D5365-1 S016568	4	0	0	0
	M304EX0.75-16F S019329	48	700	0	0
	M304TS0.750W.065 S001195	51	1,053	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description W S022455 Basket Base Assembly		Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
PART NO: D3172-041 Revision: Operation: Change No:		Start up Operation Mfg Date: 12/14/17 Job No: 168686		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Cuts ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Wrong Stock Ruled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____					